Work Orde											Page 1
Item ID: Revision ID:	D3492-043			Accept				s	etup Star		
Item Name: Start Date: Required Date: Reference:	Plug Assembly 3/3/2011 3/7/2011	Start Qty: 80.00 Req'd Qty: 80.00			Cust Item I Customer:	D:			Stop		
Approvals:	Process Plan	ı:	Date:	Tooling: SPC (Y/N):	•	ate:		R	tun Star Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3492	Rev	C	1,14.	-125		· · · · · · · · · · · · · · · · · · ·			· · · · · · · · · · · · · · · · · · ·		
Hardinge CNC Lath		Hardinge CNC LATHE Memo 1-Turn as po Rev:	er Folio FA632 & Dwg	0.00 0.00 D3492□Dwg Rev: <u></u> [11/3/7				80	\$		
QC Quality Control		QC2- Inspect parts off m	nachine FAI/FAIB	0.00				80	<i>p</i>		
QC Quality Control		QC8- Inspect parts - sec Memo	ond check	0.00 B.A 1103	 07	Y.		80	- φ		

Dart Ae	ospace	e Liu								,
W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	į į									
Part No		PAR #:								
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORI	MANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action S Action Descriptio	Section B	Sign &		cation	Approval Chief Eng	Approval
		Section A	Chief Eng	Chief Eng		Date	Seci	ion C	Chief Eng	QC Inspector
										·

Work Order ID 66931



Page 2

Thursday, March 03, 2011 8:02:17 AM

Item ID:

D3492-043

Accept

Setup Start



Stop



Revision ID: Item Name:

Start Date:

Plug Assembly

Required Date: 3/7/2011

3/3/2011

Start Qty: 80.00 Req'd Qty: 80.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Start Run



Date:_____

SPC (Y/N):

Set Up/

Tool ID

Tool # Plan

Code

Accept

Stop

Insp.

Sequence ID/ **Work Center ID**

130

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

Run Hours

0.00

Oty

Reject Oty

Reject Number

Stamp

0.00

140

Powdercoat Powder Coating White Gloss(Ref: 4.3.5.1) per QSI005 4.3-Alum

0.00

M 115951.

Memo

0.00

(Flat End Only)□START TIME:
TEMPERATURE: □FINISH TIME:

80. BR 11-3-8

150

QC

QC3- Inspect Part Finish

0.00

Memo

0.00

80 6 M (103/09)

Quality Control

Dart Aerospace Ltd

	P	/ — 1 — 1							
W/O:			W	ORK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C Clo	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
						,			
		,	1						
•	ť	,						į	
						i.			

Work Order ID 66931

Thursday, March 03, 2011 8:02:17 AM



Page 3

Item ID:

D3492-043

Accept

Setup Start

Stop

Stop

Revision ID:

Item Name:

Plug Assembly

Start Date:

3/3/2011

Start Qty: 80.00

Req'd Qty: 80.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Required Date: 3/7/2011

Date: _____

SPC (Y/N):

Date:

Tool # Plan

Code

Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

160

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours**

0.00

0.00

Accept

Packaging

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

Duit /10	oopaoo								
W/O:			WO	RK ORDER CHANGE	S				,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA		Date: _	
	Re	esolution:	Disposition	:	QA: N/C Cl	osed:		Date: _	
NCR:	·		WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	ation	Approvai	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector
						-			
						j			
	}								1

Picklist Print

Thursday, March 03, 2011 8:02:14 AM

Work Order ID: 66931

Parent Item: D3492-043

Parent Item Name: Plug Assembly

Start Date: 3/3/2011

Required Date: 3/7/2011

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP Rev: A 06.03.21 New Issue JLM

IPP Rev:B 06-08-28 As per Rev B JLM

IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

IPP Rev:D 08-05-07 add note to count gty DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	46.1898	0.0625	5.263158	11/	ジ ヲ	
				Location		Loc (<u>Oty</u>	Loc Code					
				MAT		46	5.173						
					115469	0.0	0027		_				
						_							

MAT 46.173

115469 0.0027

115869 2.4453

116406 43.725

MAT012 0.016842105

112442 0.01684211

4.584

Dart Aerospace Ltd

	•							
W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							T Tod Wigi	
						İ	ļ	
					3 3 1			
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	ı:	QA: N/C Cld	sed:	Date: _	
NCR:		· · ·	WORK ORDE	R NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC	<u> </u>		tion B	Verification	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								•

D3492-XX PLUG (SEE TABLE)-

-NAS1611 PLUG (SEE TABLE)

w/o 66931

D3492-XXX PLUG PARTS LIST

×10	OTY	atv	OIY	arr	DITY	QTY	PART NUMBER	DESCRIPTION
-041	043	-045	-047	-049	-051	-053	D3492-041	PLUG ASSEMBLY
X							D3492-043	PLUG ASSEMBLY
	X	L					D3492-045	PLUG ASSEMBLY
		X				 	D3492-847	PLUG ASSEMBLY
			X				D3492-049	PLUG ASSEMBLY
	T	L	<u> </u>	X	X		D3492-051	PLUG ASSEMBLY
		<u> </u>	<u> </u>		<u>: ^</u>	X	D3492-053	PLUG ASSEMBLY
	Ι	L	 	 		 ^		T
		_	 	 			D3492-1	PLUG
1		1	-		ļ	+	D3492-3	PLUG
	1		<u> </u>				D3492-5	PLUG
	T	1_1_			┼──	 	D3492-7	PLUG
	1	1	! 1_	4	┼		D3492-9	PLUG
		 -		1 1			D3492-11	PLUG
						1	D3492-13	PLUG
					1			
: .]	1	İ		+-	+	NAS1611-005	O-RING
i	<u>.</u>	11_	+			+	NAS1611-007	O-RING
							NAS1611-010	O-RING
1				ㅗ	+-	1	NAS1611-012	Q-RING
							NAS1611-013	O-RING
	1				1		NAS1611-015	O-RING
	I			1	1-		NAS1611-016	O-RING

<u>A</u> A <u>A</u>

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

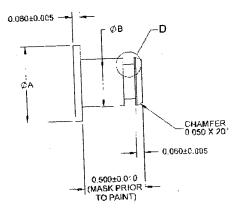
DEO ATTACHED

	Lann mar	061-053 CH	ANGE DRAWING FORMAT	PF	07.10.05
С			A FOR -045	P⊦	06.05.11
8.			A P O N - 043	PI-	06.01.C4
A	NEW ISSU			BY	DATE
REV.	DESCRIPT	ЮИ			
DESIG	N.	14	DART AEROS	SPACE L	TD
DRAV	M.	1964	HAWKESBURY, ON	TARIO, CANA	
CHEC		- 1	DRAWING NO		REV. C
		24 C	D3492		SHEET 1 OF 2
MFG.		<u> </u>	TITLE		SCALE
APPR	OVED	_/V#			2:1
DE AF	PPR.		PLUG		
DATE	07.10	0.05	COPYPISHT © 2007 BY D THE DOCUMENT & PITALITY OF COMPANIES AND A HOT TO BE DECEMBED TO THE PITALITY OF THE PI	201 4 0477-14049 YAL 74 20140-170 DE 146 DE 140	
1					

8

ŝ

POWDER COAT THESE FACES ONLY PER NOTE 2



D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	C	MATERIAL SPEC
3492-1	0.625	0.394	0.055	ME061T6R0.625
3492-1	0.750	0.582	0.045	ME061T6R0.750
3492-5		D.138	0.045	M6061T6R0.375
33492-7	0.500	0.270	0.045	M6061T6R0.500
03492-9		0.750	0.045	Me081T6R1.000
)3492-11		0.664	8.045	M6061T6R0.875
3492-13		0.520	0.045	M6061T6R0.750

NOTES:

1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) QQ-A-225/8 (6061) OR QQ-A-225/1 (1100) QQ-A-225

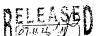
+ 0.090 +0.000 -0.002 $c_{-0.002}^{+0.000}$

DETAIL D

v/0 66931



DEO ATTACHED



υ

C

DESIGN DRAVIN	P.H.	DART AERO HAWKESBURY, OF	SPACE LTD NTARIO, CANAUA
	7	DRAWING NO.	REV. C
MEG. APPR.	1 TE 13	_ D3492	SHEET 2 OF 2
APPRÓVEO	A Park	TITLE	SCALE
	400	PLUG	4:1
DE APPR. DATE 07.	10.05	COPYRIGHT 6 2007 BY	DART AEROSPACE LTD 6 46-91-46-91-92-92-92-93-93-93-93-93-93-93-93-93-93-93-93-93-

C

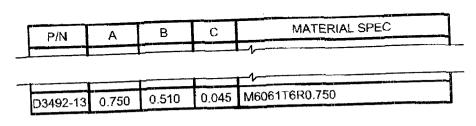
â

3				TO A PROCESS OF A CELT	D.E.O. NO.	SHEET NO.	SCALE
DRAWING NO.	TITLE		REV. C	DART AEROSPACE LTI ENGINEERING ORDER	D3492-C-1	SHEET 1 OF 1	NTS
D3492	PLUG		· · · · · · · · · · · · · · · · · · ·	MFG. APPR. B	APPROVED /	DE APPR.	
DRAWN AJS	S	CHECKED			DATE 08/11/05	DATE 08 / H / OS	5
DATE 08.11		DATE 08	2.0.05	DATE 08. ((. 6)	DATE		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS



WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	Α	В	С	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	1 M6061T6R0.750



TO THE PARTY OF LAND	Work Order:	66131
DART AEROSPACE LTD	The second secon	D3492-3
Description: Plug	Part Number:	D3432-0
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	ie	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	02749	1		Vol	34-7
Ø0.582	+0.008/-0.001	0.582				
0.045	+0.000/-0.002	.044	/			
0.060	+/-0.005	060		<u> </u>	, , , , , , , , , , , , , , , , , , , ,	
0.060	+/-0.005	060			·	
0.500	+/-0.010	, 100			ļ	
0.090	+0.000/-0.002	.089				
			-			
	4		+	 		
			-	+	1	
			 			
	Į.	i i	1	1	1	

	A . disad by	y. A	Prototype Approval:	N/A
Measured by:	Audited by:	<u> </u>	Date:	N/A
Date: 11/3	Date:	11/03/07	Revised by	Approved

Ĺ			Revised by Appro	oved
ļ	Rev	Date	Change KJ/JLM	
	Α	06.07.07	1 14 CV 13300	<u> </u>
	В			
	C	08.09.04	Tolerance revised for Ø0.750	